



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4956-23

Job Sheet 168973



Part No: D4956-23

Job Qty: 4 ea

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/28/17

Job Tracking No:

Due Date: 11/29/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEETS 4,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/28/17	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	4 pcs		11/28/17	0.00	1.11	Waterjet1		SC
120	QC	4 pcs		11/28/17	0.00	0.00	QC8		SC
130	Brake NC	4 pcs		11/28/17	0.15	0.18	Brake NC 1		SC
140	QC	4 pcs		11/28/17	0.00	0.00	QC5		SC
150	HandFinish	4 pcs		11/29/17	0.00	0.39	HandFinish4		AL NOV 28 2017
160	QC	4 pcs		11/29/17	0.00	0.00	QC3		AL NOV 28 2017
170	Packaging	4 pcs		11/29/17	0.00	0.00	Packaging3		DEF 2017/11/29
180	QC21-SA	4 Ea		11/29/17	0.00	0.00	QC21		DEF 2017/11/29

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S20GA	5	171	0	0

Rockguard 138637

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use ☐ Suspected ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	MRB (QSI042) Approval _____ _____ _____														
Description: _____ Mtg Date: 11/28/17 Job No: 168973		Completed By _____ _____														
Lead hand / Supervisor Approval Verification _____ _____		QC / QA Coordinator Approval _____ _____														

PART NO: _____
 Revision: _____
 Operation: _____
 Change No: _____

Start up operation
 D4956-23

Wearplate Center Fwd
 S014711
 DART AEROSPACE

Root Cause	Category	Description	Action	Status	Remarks
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	OTHER : _____ _____ _____

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875		
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
6	Wearshoe	6.750Inches ± 0.010	6.760 6.740		
7	Wearshoe	11.500Inches ± 0.010	11.510 11.490		
8	Wearshoe	16.750Inches ± 0.010	16.760 16.740		
9	Wearshoe	25.140Inches ± 0.010	25.150 25.130		
10	Wearshoe	30.530Inches ± 0.010	30.540 30.520		
11	Wearshoe	35.920Inches ± 0.010	35.930 35.910		
12	Wearshoe	41.310Inches ± 0.010	41.320 41.300		
13	Wearshoe	46.700Inches ± 0.010	46.710 46.690		
14	Wearshoe	50.200Inches ± 0.010	50.210 50.190		
15	Wearshoe	54.850Inches ± 0.010	54.860 54.840		
16	Wearshoe	56.850Inches ± 0.030	56.880 56.820		
17	Wearshoe	6.000Inches ± 0.030	6.030 5.970		
18	Wearshoe	14.000Inches ± 0.030	14.030 13.970		
19	Wearshoe	22.000Inches ± 0.030	22.030 21.970		
20	Wearshoe	30.000Inches ± 0.030	30.030 29.970		
21	Wearshoe	38.000Inches ± 0.030	38.030 37.970		
22	Wearshoe	45.000Inches ± 0.030	45.030 44.970		
23	Wearshoe	54.000Inches ± 0.030	54.030 53.970		

Plex 11/28/17 10:31 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

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